

Date: Monday, 8/21/2006 2:12:12 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE	
Job Number	: 28262		Part Number	: D29331	
Estimate Number	: 10833		Drawing Number	: D2933 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 8/21/2006 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/20/2006 Qty: 8 Um: Each	
Previous Run	: 27411				
Written By	:				
Checked & Approved By	: <i>dk</i> 06.08.21				
Comment	: Est: B00.06.26 New DWG rev (mpp 2069) EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <u>25344</u>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet		
4.0	QC1	INSPECT ALL DIM TO DIM SHEET 
Comment: INSPECT ALL DIM TO DIM SHEET		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: Date: 06/09/14

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 8/21/2006 2:12:12 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 28262

Part Number: D29331

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
7.0	POWDER COATING	POWDER COATING
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
9.0	PACKAGING 1	PACKAGING RESOURCE #1
10.0	DC	DOCUMENT CONTROL

Job Completion



u 06/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	28262
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.121	.121	.121		
B	0.100	0.140		.120	.121	.121	.121		
C	0.100	0.140		.129	.129	.125	.128		
D	0.210	0.230		.221	.221	.220	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.499	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.576	1.576	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.239	.238	.238	.239		
N	0.100	0.140		.120	.121	.121	.120		
O	0.540	0.560		.550	.549	.550	.550		
P	0.490	0.510		.501	.500	.500	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.719		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.251	.250	.250	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.630	1.629		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.125	1.145		1.135	1.134	1.134	1.134		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.	Audited by:	E.
Date:	06/09/07	Date:	06/09/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

DART AEROSPACE LTD			Work Order:	28262
Description: 206 Saddle, Inboard, Left side			Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B			Page 1 of 1	

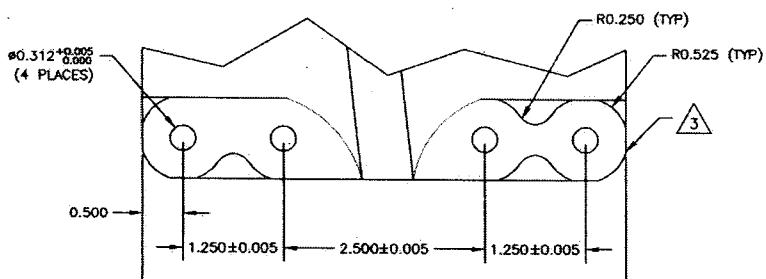
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

			Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.120	.122	.121		
B	0.100	0.140		.121	.120	.122	.120		
C	0.100	0.140		.126	.125	.126	.125		
D	0.210	0.230		.220	.220	.220	.221		
E	1.245	1.255		1.250	1.249	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.499	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.576	1.577	1.577		
J	2.495	2.505		2.500	2.499	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.238	.239	.239	.238		
N	0.100	0.140		.121	.121	.121	.121		
O	0.540	0.560		.550	.551	.550	.549		
P	0.490	0.510		.499	.500	.500	.500		
Q	3.715	3.725		3.719	3.720	3.720	3.719		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.250	.250	.251	.249		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.629	1.630	1.630		
V	1.362	1.372		1.366	1.367	1.367	1.366		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.125	1.145		1.134	1.134	1.133	1.133		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

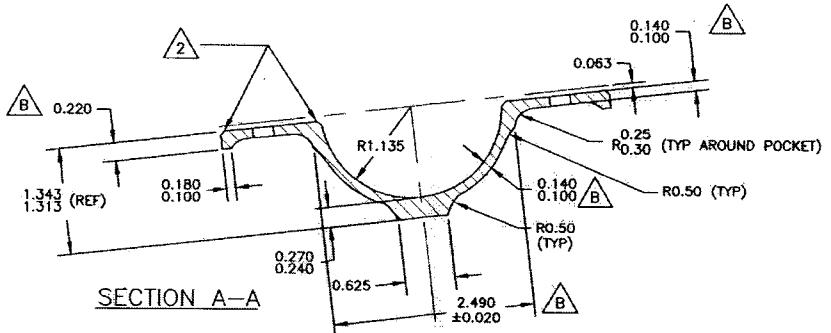
Measured by:	J.L.
Date:	06/09/07

Audited by:	E
Date:	06/09/08

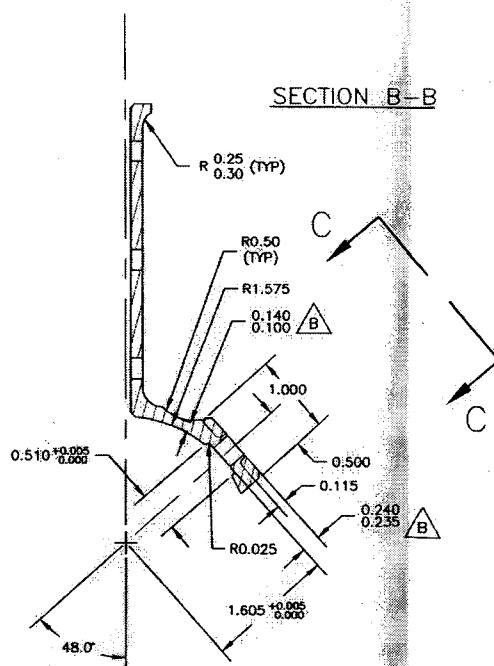
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	**



VIEW C-C



SECTION A-A



SECTION B-B

D2933-1 LH SADDLE (SHOWN)

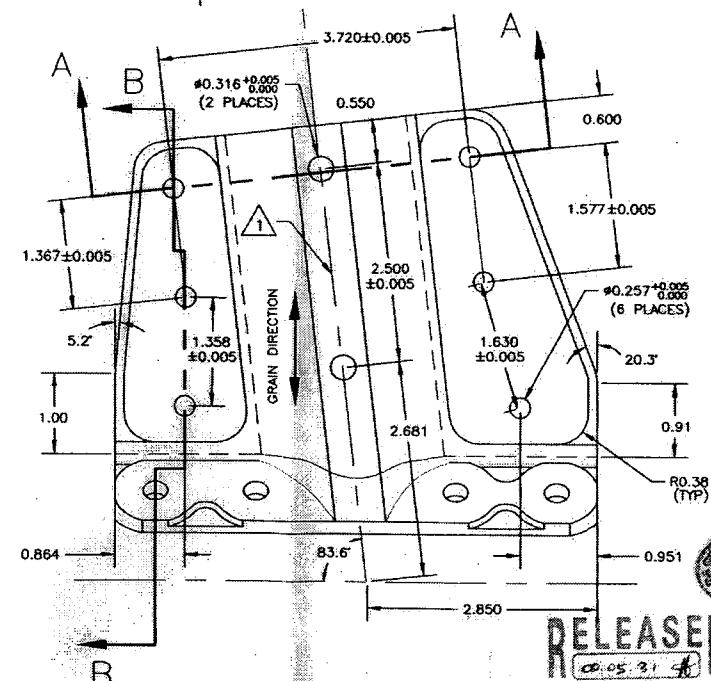
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 038 UNLESS OTHERWISE NOTED

1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)

3 CHAMFER 0.050" x 45°



RELEASED
08-05-2014

B	00.05.29	CHANGED GEOMETRY AND MATERIAL		
A	99.10.29	NEW ISSUE		
DESIGN	DRAWN BY	DART		DART AEROSPACE USA, INC. BELLEVUE, VA
CHECKED	APPROVED	DRAWING NO.	REV. E	
		D2933	SHEET 1 OF 2	
DATE	TITLE		SCALE	
00.05.29	SADDLE INSIDE		2:	